

Date: Wednesday, 5/31/2006 7:40:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER ASSEMBLY
Job Number : 27311	
Estimate Number : 10301	
P.O. Number : N/A	Part Number : D2370
This Issue : 5/31/2006 S.O. No. : N/A	Drawing Number : D2370
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B1
Previous Run : 26756	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 6/20/2006
Checked & Approved By : [Signature]	Qty: 2 Um: Each
Comment : Est D 01.10.10 Changed D2484 nut for D3015-1 SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue p/o: 1373

c 206105/31 (2)

Order: Model 12-2A undrilled with grey pad & black belts

Supplier: Ferno Aviation

Letter of compliance required

2.0

D2370P

Litter Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Litter Assembly

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage

Insure that letter of compliance is attached to w/o

SL 06/06/06 (2)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

[Signature] 06-06-07 (2)

5.0

D2374

Stud

**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Stud

Pick:

Qty Part Number

Description

Batch

4

D2374

Stud

~~1326459~~

1326459

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:40:43 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER ASSEMBLY

Job Number: 27311

Part Number: D2370

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2378

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	D2378	Mounting Bolt	B22015C (16) B22015B (2)

7.0

D30151

Lock Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lock Nut

Pick:

Qty	Part Number	Description	Batch
4	D3015-1	Lock Nut	B14710

8.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	AN960JD416L	Washer	M3154

SAD 06:06:07

(2)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2370

2-Drill 0.191" holes as per Dwg D2370

3-Deburr

SAD 06:06:07

(2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 06:06:07 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

175

SAD 06/06/07 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/08

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER ASSEMBLY

Job Number: 27311

Part Number: D2370

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/08 (2)

Job Completion



u 06/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2370	REV. B SHEET 1 OF 2
DATE 98.06.09		TITLE LITTER ASSEMBLY	SCALE NTS
A	95.02.20	NEW ISSUE	
B	98.06.09	ADDED Ø0.191 HOLES	
B1	01.10.10	ADD ALTERNATE FOR D2484	

RELEASED
98/06/15 KE

CP

D2370	Part No.	Description
X	D2370	LITTER ASSEMBLY
1	D2485	LITTER FRAME
2	D2379	RESTRAINT BELTS
4	D2374	STUD
4	D2378	MOUNTING BOLT
1	D2381-1	LITTER PAD
1	D2381-3	LITTER PAD
4	D2484	NUT (<i>OR D3015-1</i>)
4	AN960JD416L	WASHER

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WITHOUT NOTICE

WORK ORDER

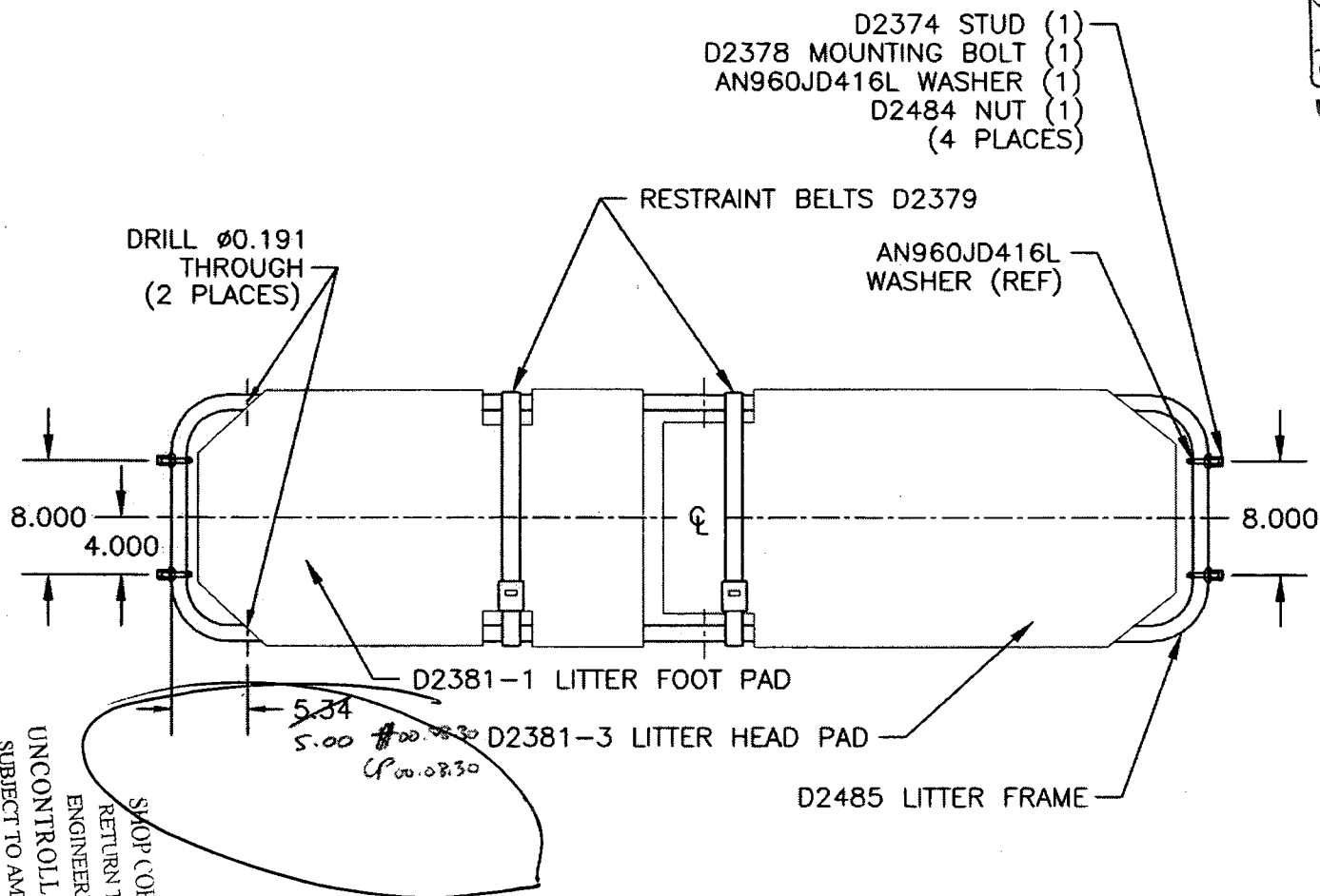
NO. 27311

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. 8
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2370	SHEET 2 OF 2
DATE 98.06.09	TITLE LITTER ASSEMBLY	SCALE 1:12	

RELEASED
48/06/15 KE



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WORK ORDER



70 Weil Way ! Wilmington, OH 45177-9371 ! (937) 382-1451 ! FAX (937) 382-1191
Int'l FAX (937) 382-6569
Visit us at our web site: www.ferno.com

23 May, 2006

Certificate of Conformance

Manufacturer: Ferno-Washington, Inc.

Manufacturer's Address: 70 Weil Way
Wilmington, OH 45177-9371
USA

Order No. C-781812

Reference P.O. 3775

Ferno Model No. 12-2 Stretcher

Ferno Serial No. 06-012088; 06-012091; 06-012089; 06-012090;
06-012087; 06-012085; 06-012086

P/O 1373

I certify that the above referenced products were produced in accordance with applicable Ferno-Washington engineering standards using approved manufacturing methods and materials. The products have been inspected using approved test procedures and inspection criteria for Ferno-Washington medical devices. Ferno-Washington has a Quality Assurance system.

Dorothy Deaton

[Signature]

Dorothy Deaton
Regulatory Affairs

Certificate of Analysis



Client:		Foam Type:	11032 CFR
Ohio Foam Corporation		Lot Number:	71805
1511 South Alum Creek			Blue
Columbus, Ohio 43209		Fax:	614-252-1213

Test	Methods	Frequency	Requirements	Results
Density (lbs per cubic ft.)	ASTM D3574-03 Test A	Daily	1.05 - 1.15	1.09
IFD (4" 25% lbs/50 sq in.)	ASTM D3574-03 B1	Daily	28 - 38	29.81
Tensile Strength (As rec'd psi) min	ASTM D3574-03 Test E	Monthly	12.0	13.94
Tear Strength (lbs per inch) min	ASTM D3574-03 Test F	Monthly	1.2	1.88
Elongation (% min)	ASTM D3574-03 Test E	Monthly	120%	210%
Flammability	CAL Burn Test (TIB 117)	Daily	PASS	PASS ✓
	MVSS302	Daily	PASS	PASS
Air Flow (1" Thick) min	Q1-104	Daily	3.5	3.56

Authorized Signature

Date:

8-2-05

FLEXIBLE FOAM PRODUCTS, INC.

200 East North St, P.O. Box 124
 Spencerville, OH 43087
 Ph. (419) 647-4172 Fax (419) 647-6720